

Date: Thursday, 2/9/2006 1:39:58 PM  
User: Kim Johnston

## **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: 350/212/130 BASKET LID.		
<b>Job Number</b>	: 25756B			<b>Part Number</b>	: D2512		
<b>Estimate Number</b>	: 10193			<b>Drawing Number</b>	: D2512 REV D1		
<b>P.O. Number</b>	: N/A			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 2/9/2006	<b>S.O. No.</b>	: N/A	<b>Drawing Revision</b>	: D1		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	: N/A		
<b>First Issue</b>	: N/A			<b>Due Date</b>	: 2/22/2006	<b>Qty:</b>	1
<b>Previous Run</b>	: 25754B			<b>Um:</b>	Each		
<b>Written By</b>	<u>See Comment Below</u>			<b>Comment</b>	Rev Est:M 02.01.31 Added D2012-117 for D130-701-041 KJ/ RF		
<b>Checked &amp; Approved By</b>	<u>KJ 06.02.10</u>						

#### **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W 
		
	Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
	Pick: 3/4"x3/4" 304/316 SS tube .063" wall Batch: <u>B25896</u> M100138	PD 06-03-09
2.0	D31663	Basket Hoop 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	(1)
	Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B25896</u>	PD 06-03-09
3.0	D2506	Placard 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	(1)
	Pick: Qty Part Number Description Batch 1 D2506 Label Plate <u>B24875</u>	PD 06-03-09
4.0	D23271	Spacer Bushing 
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	(2)
	Pick: Qty Part Number Description Batch 2 D2327-1 Bushing <u>B24875</u>	PD 06-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:39:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25756B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2232-1	Hinge plate	B23445
-		

(2)

PD

06-03-09

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2581	Mounting Bracket	B2513A (1) B25834 (1)
-		

(2)

PD 06-03-14

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number	Description	Batch
18 sf	M304EX0.75-16F Expanded Metal	M100230
-		

PD

06-03-14

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.

EC130 Basket only

Pick:

Qty Part Number	Description	Batch
2 D2012-117	Clevis	
-		

(1)

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PD

06-03-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:39:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25756B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

M 06/03/16 (1)

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/17 (1)

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray M19640

Batch: 100037

M 06/03/17 (1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DC 06/03/20 (1)

Job Completion



M 06/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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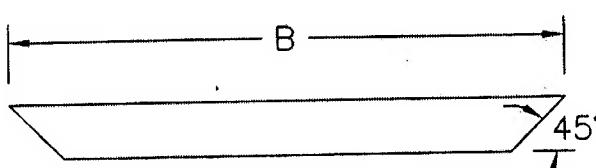
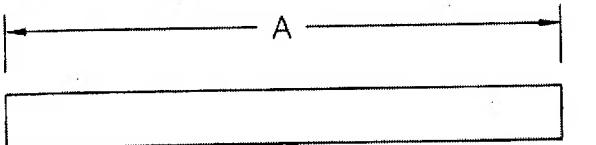
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CHECKED <i>off</i>	APPROVED <i>off</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

RELEASED  
01.04.27 *HP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	<del>HP</del> 03.01.20	ADD D2012-117 FOR D130-701-041
D2	<del>HP</del> 09.09.20	TACK WELD ANTI-SKID AREA

### PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

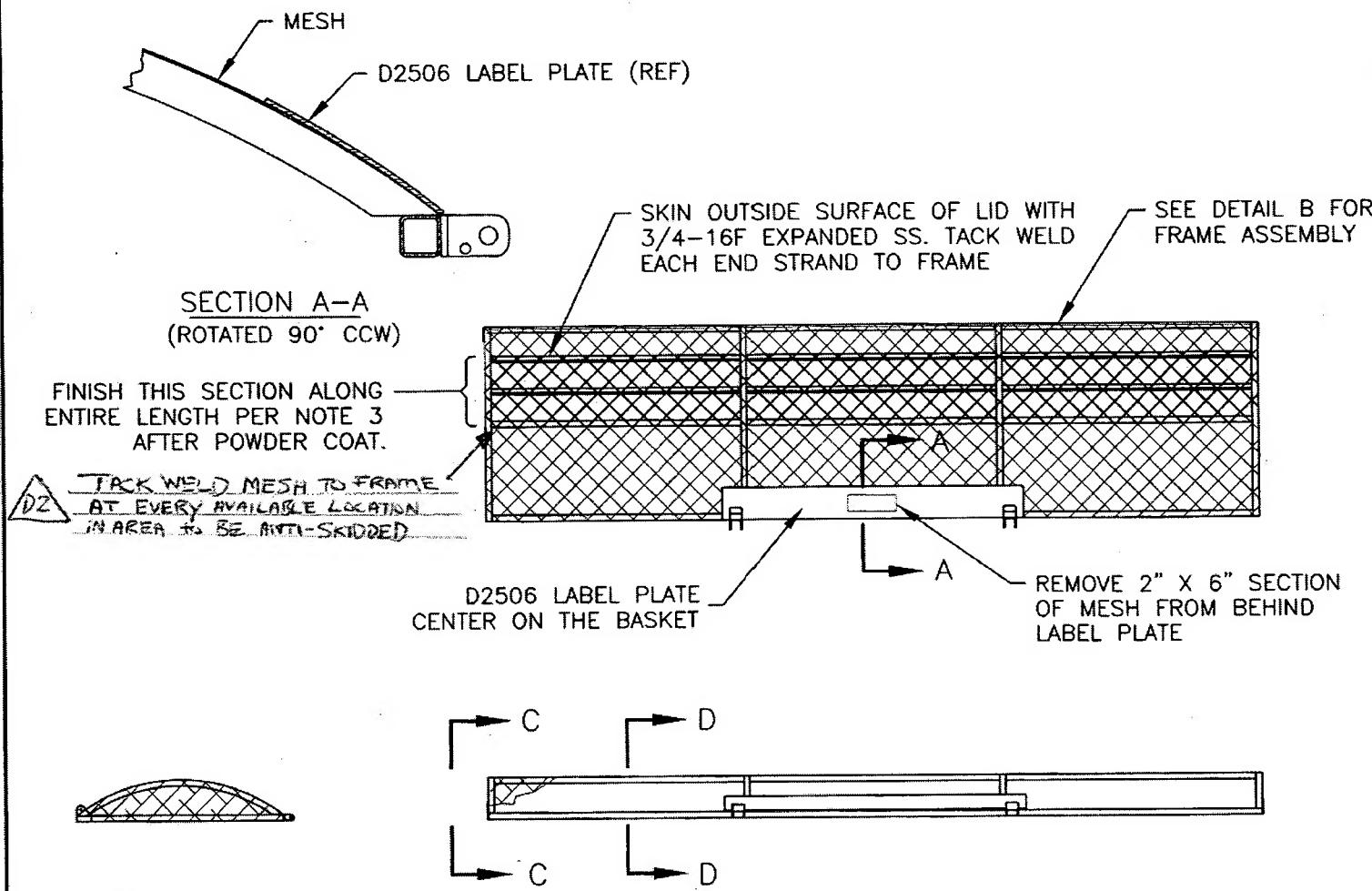
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CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2512
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)

**D2512 BASKET LID ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

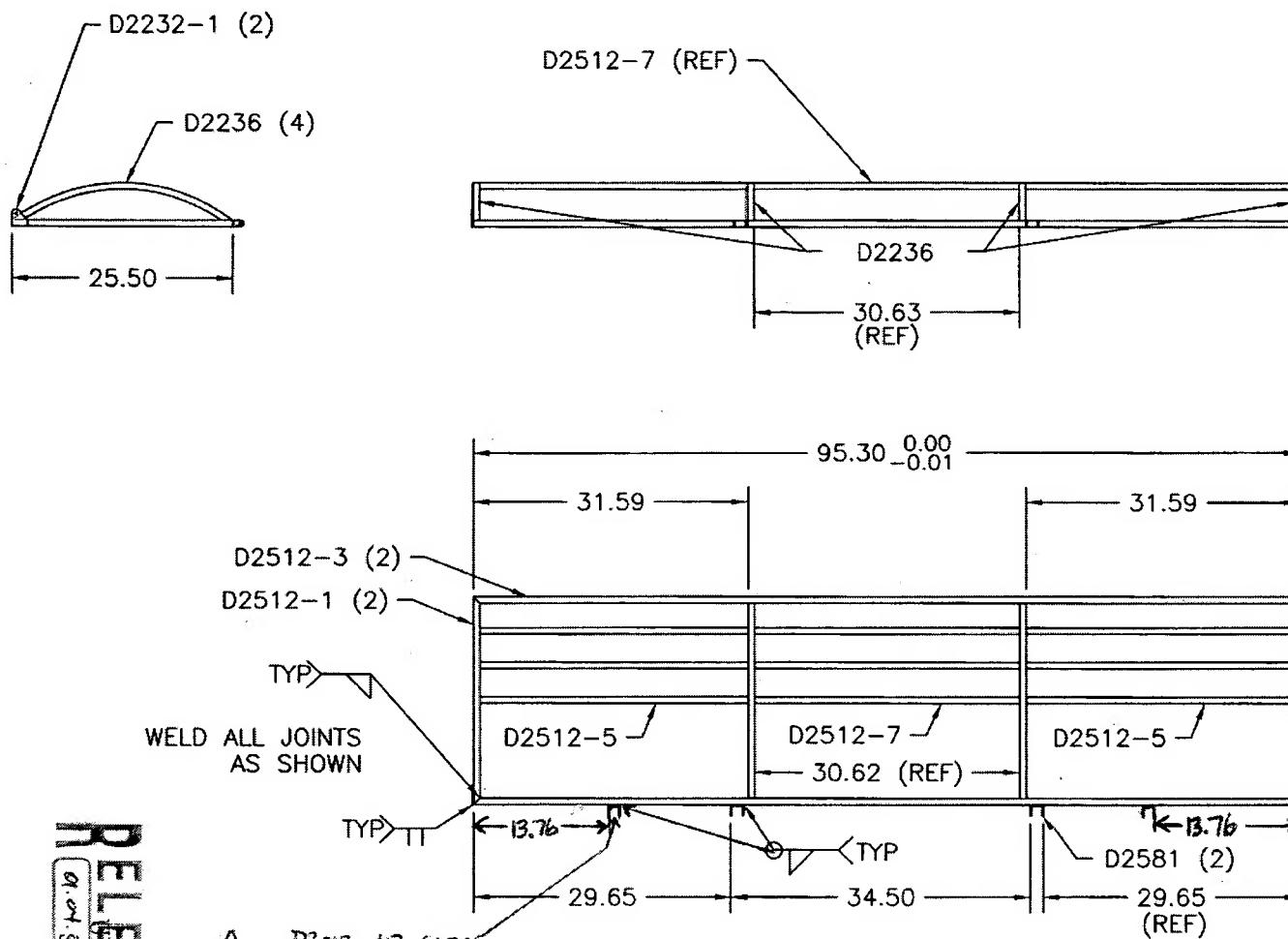
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DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4 SCALE 1:20

**DETAIL B**

FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
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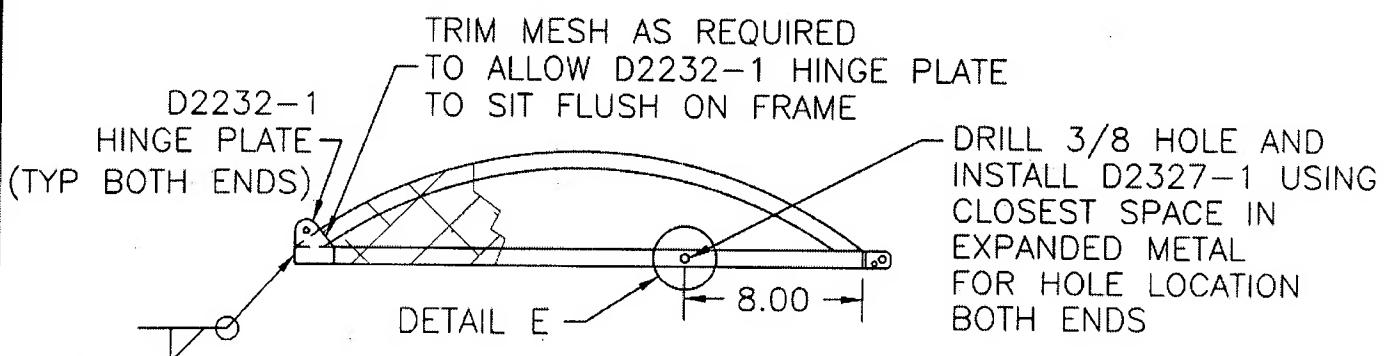
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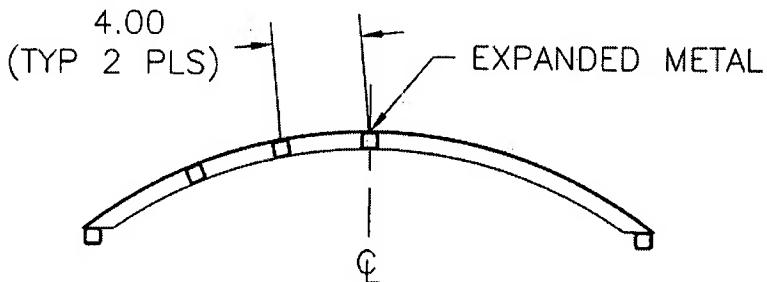
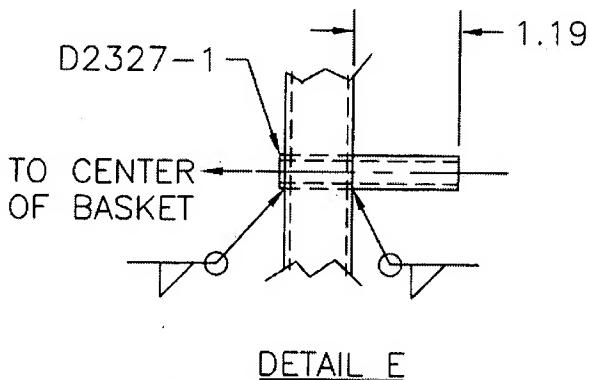
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DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILAR BOTH END RIBS



SECTION D-D SAME BOTH CENTER RIBS

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